

FORM	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				TECHNICAL PAPERS		
			9Д4.180.026Cx.	PACKING DIAGRAM		
			OCT 100859-77.	PACKING BOXES		
				<u>PARTS</u>		
				<u>STANDARD UNITS</u>		
		1		PACKING BOX 5774A-3-3.		1 PIECE FOR SIX UNITS ALLOWANCE P07.0105
		2		SEAL OST110067-71		1 PIECE PER BOX.
				<u>MATERIALS</u>		
				PAPER Б GOST515-77	0.5Kg	PER BOX
		3		WIRE K0φ1 GOST792-67	2.5M	PER BOX
				ENAMEL XB-16 RED AND BLACK TY6-10-1301-78.		
			D130-56			

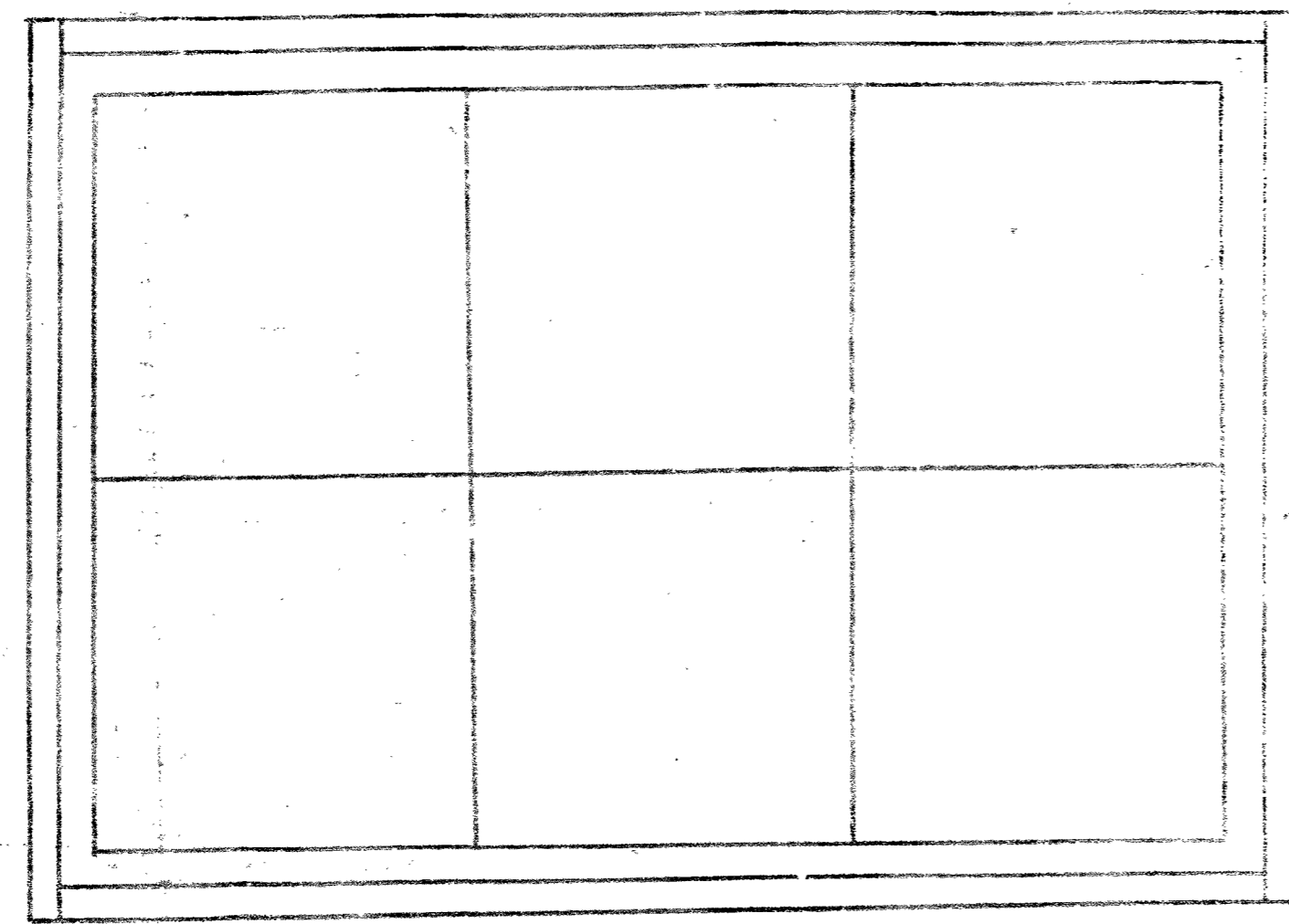
9Д4.180.026

S.NO	SHT	DOC.NO.	SIGN	DATE
	DRAWN	CH.V.RAO	<i>[Signature]</i>	22.5.8
	EDT&CHK	D.K. JAIN	<i>[Signature]</i>	24.5.8
	F/M.D.C.	S.H. RAO	<i>[Signature]</i>	31/5
	DIV.OFFR.	D.A. RAO	<i>[Signature]</i>	31/5
		NAME	SIGN	DATE

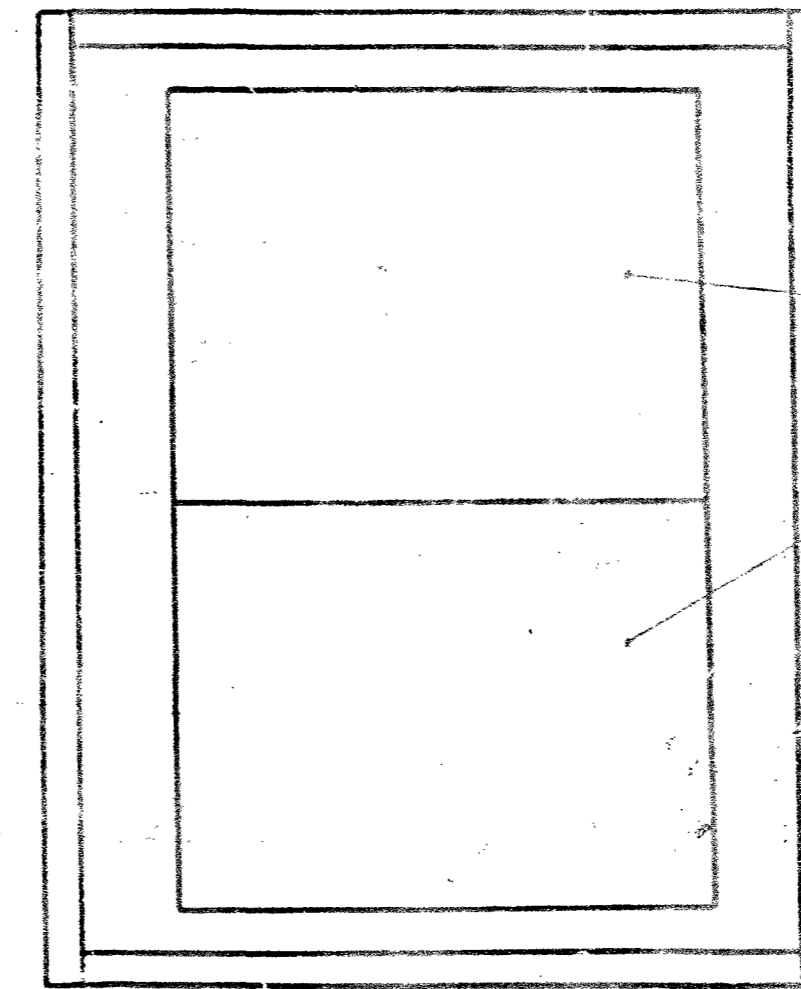
STOWAGE OF
UNIT ГПК-59

SHT. NO	NO OFF BR
1	

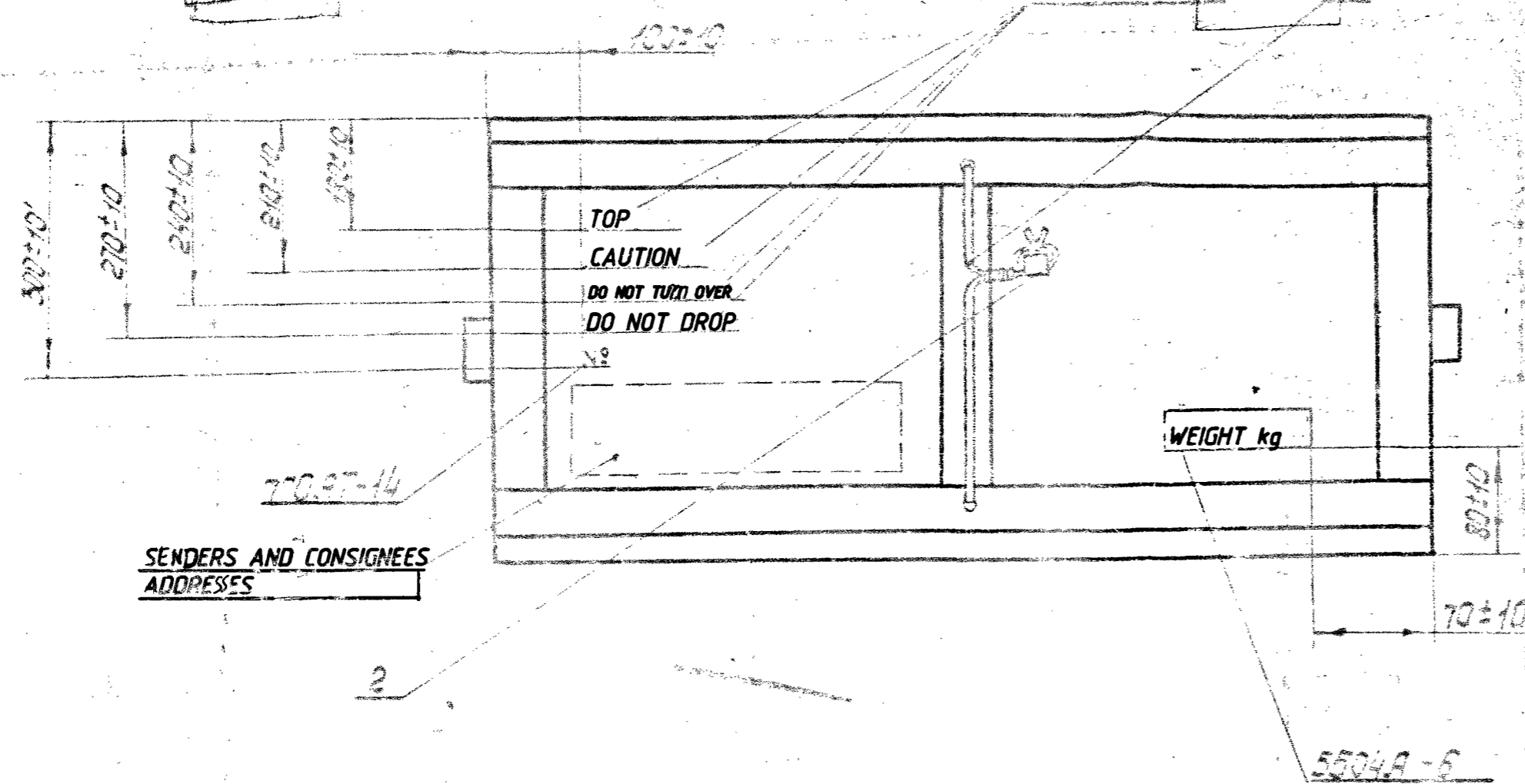
ORDNANCE FACTORY
PROJECT
HYDERABAD 52



VIEW A



Packing of unit ГПК-59.



1. Manufacturing requirements for boxes, packing and marking are as per OCT 100859-77.
2. Packing between paper 6 GOST 515-77 is laid inside at the bottom, wall and box cover.
3. Cavities are fitted with wooden chips.
4. Packing list and technical description and operational instructions (if necessary) are placed on top before closing the cover of box.
5. Inscribe "Handle with care" "Do not turn over" with red-colored enamel XB-16; TY 6-10-1301-78. Other inscriptions and symbols are made with black enamel XB-16 MPTY 6-10-1301-78.
6. Inscription "Top", "Caution", "Do not turn over", "Do not drop", "Senders and consignees address", "Weight" (see view A) are applied on two opposite walls.
7. Sealing is made as per OST 1. 10067-71.
8. For repeated use of container change broken and cracked boards and bars. Re-paint damaged places or re-painting the box completely. Re-place of broken accessories. Re-condition marking on the box.
10. The unit may be packed in box P 107.01.05.

0130-57

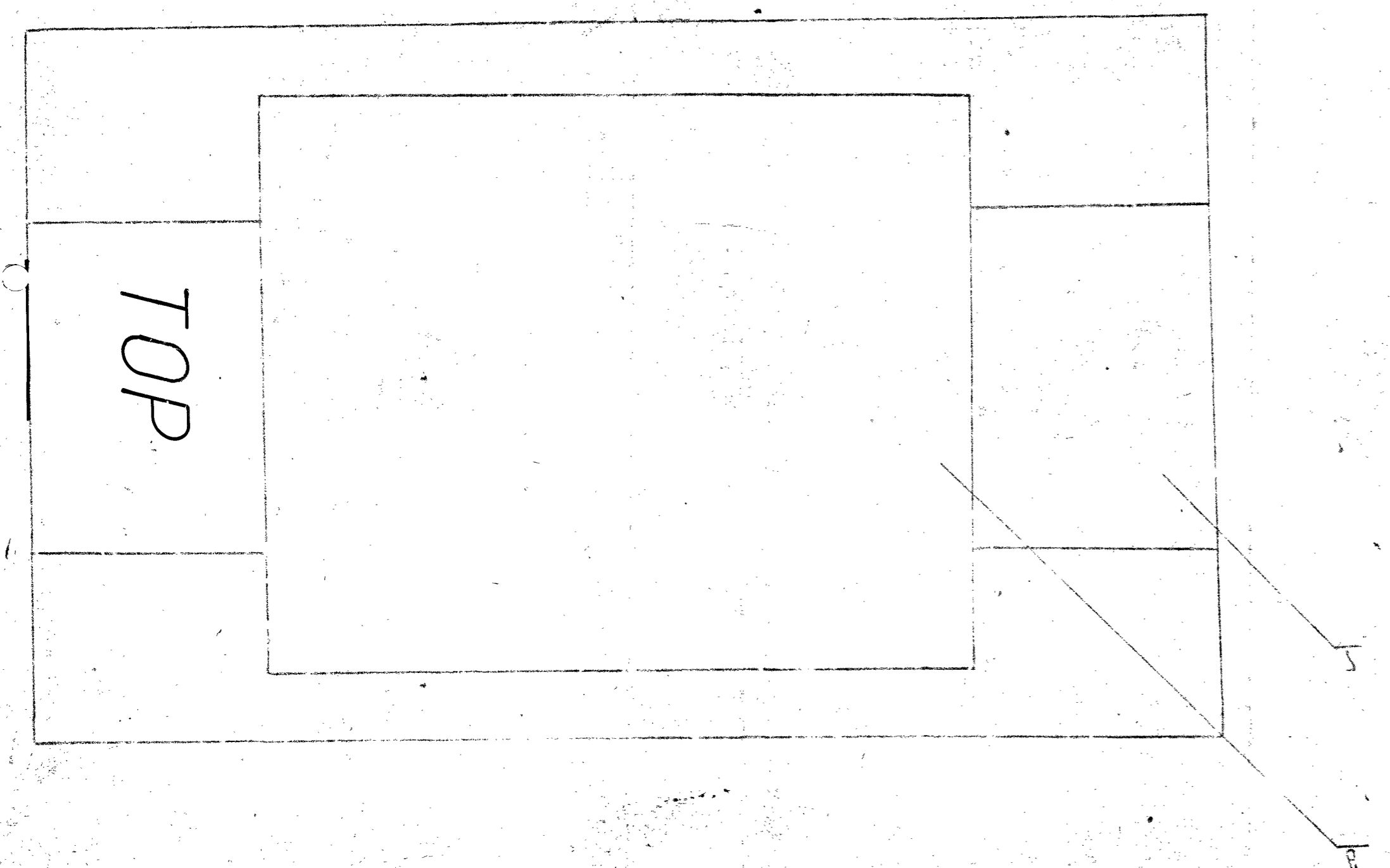
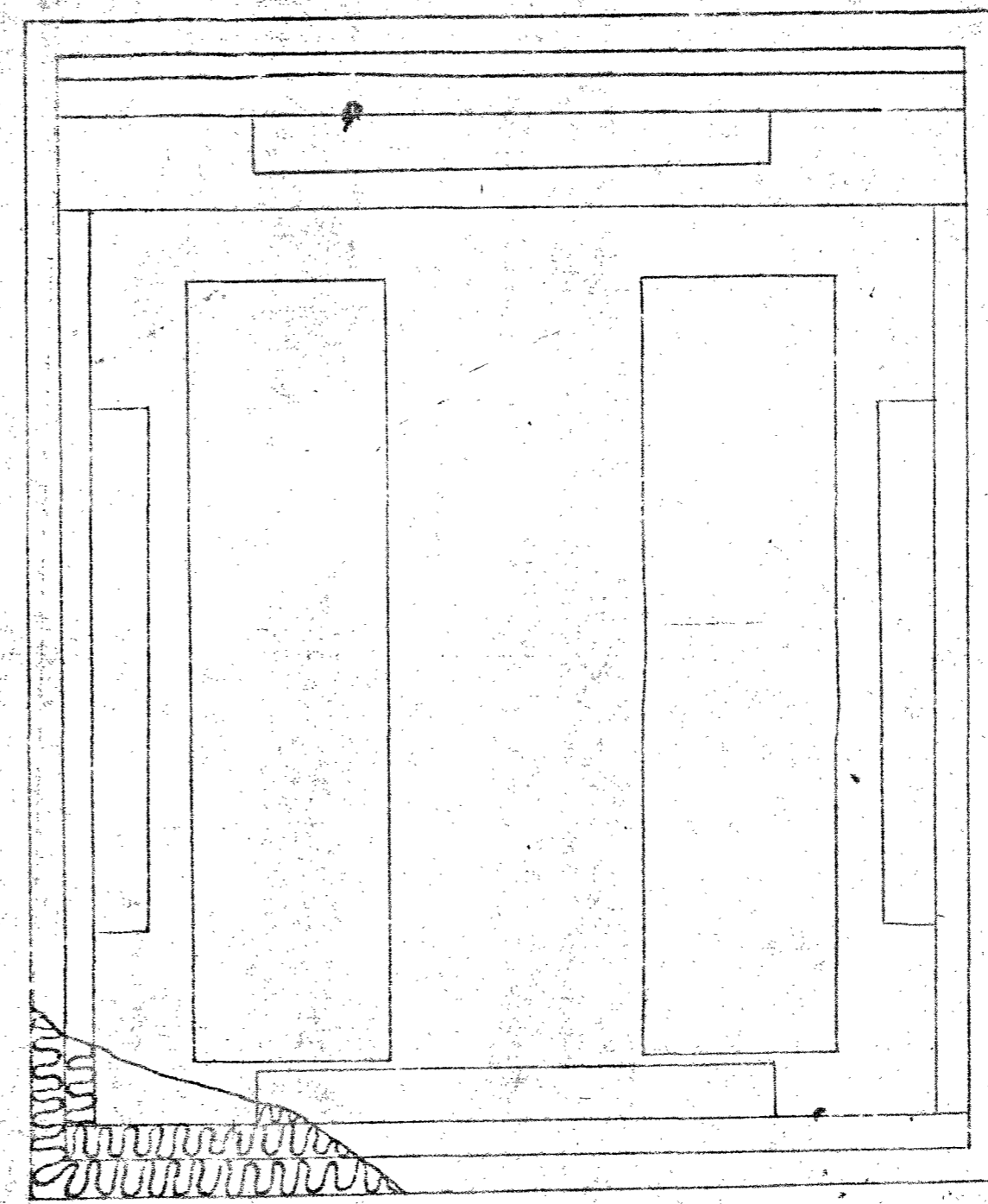
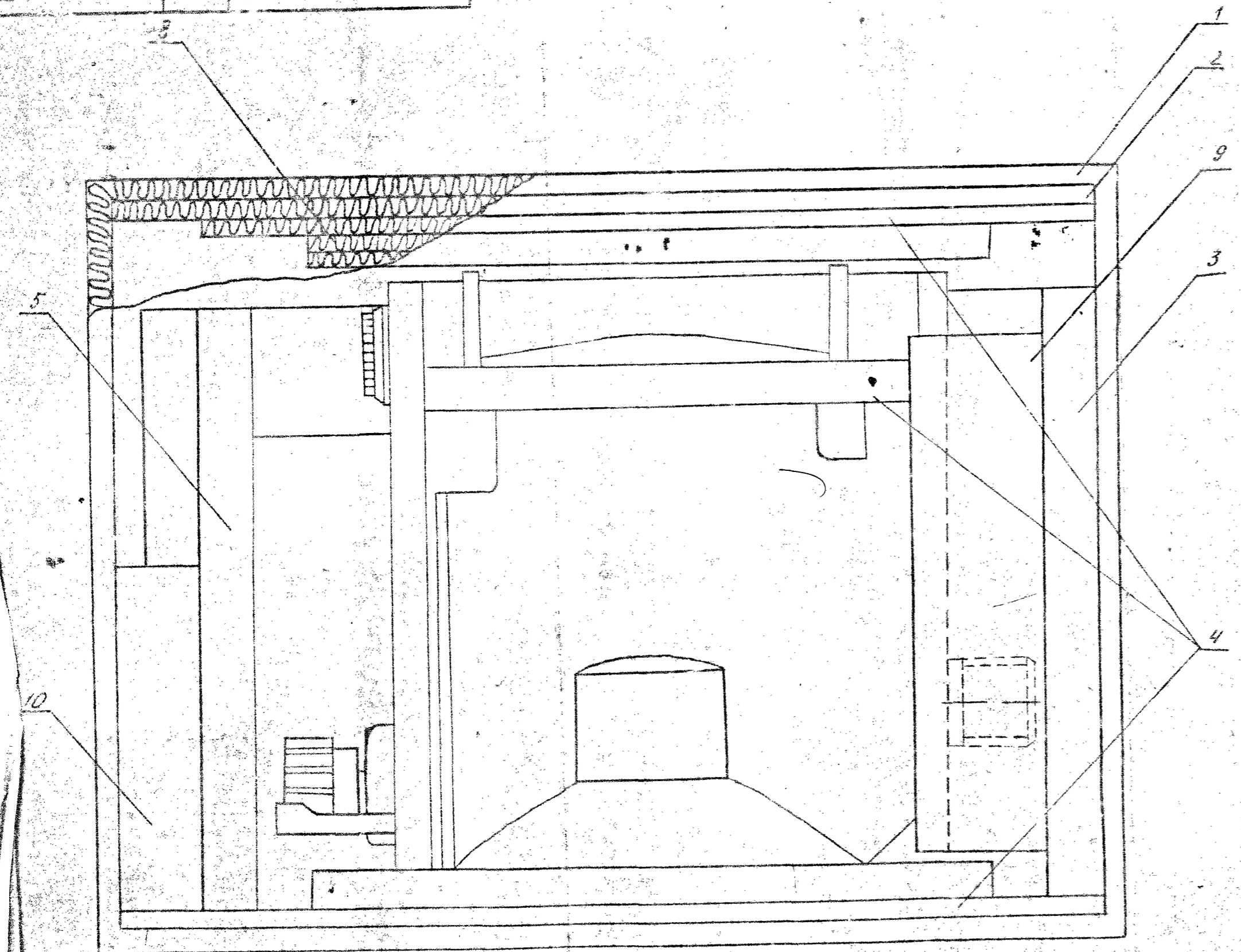
ECKM

944.180.026 Cx

SNOSH	DOC NO	SIGN	DATE	SHEET	WEIGHT	SCALE
DRAWN	PRBABL		19.5.84	51		
EDT	CHKD	DR. SAN	24.5.84			
F/M	OC	SUR	24.5.84			
DIV	OFFER					

PACKING DIAGRAM OF UNIT ГПК-59.

944 180 045 C5



1. The unit is wrapped in telephone cable paper, GOST 3553-75, Packed in box ref no 1 and covered with spacers ref nos 2, 3, 4, 5, as per drg.
2. Box ref. no. 1 with packed unit is wrapped with paper tape, width 75 mm, ref. no 7. Tag ref no 6 is glued to the cover of box above paper tape, With bone glue GOST 2067-80 symmetrically with respect to the contour of box.
3. Spare bulb MH 326-012-1 and receiving part of plug connector are wrapped in telephone cable paper and placed between spacers ref. no. 5 and wall box of ref. no. 1 as per drg.
4. Delivery list and certificate are placed between spacer ref. no. 2 and spacer ref. no. 4.
5. Strap ref. no. 8 are glued to spacers ref. no. 4, ref. no. 9 to ref. no. 3, ref. no. 10 to ref. no. 5 with bone glue GOST 2067-80 symmetrically with respect to the spacer area.

ECKO

944 180 045 C5				SHEET WEIGHT SCALE	
DRAWN	P.R.BABU	SIGN	DATE	2	61
EDT/CHKD	D.K.JAIN		19.5.84		
F/M, DC	K.H.ARO		2/15		
DIV. OFFR	D. S. S. S.		2/16		
STORAGE BOX				TOTAL SHEETS	
				ORDNANCE FACTORY PROJECT	

FORM NO	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				<u>Materials</u>		
				Telephone cable paper paper KT-0,5		
				GOST 3553-73:500 X 600	1	
				<u>PARTS</u>		
		B	127YT-1	Lable	1	
				D 130-50		

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		P.R.BABU.		25.5.80
EDT&CHK		D.K.JAIN	[Signature]	26.5.80
F/M.D.C.		S.H.RAO	[Signature]	4/15
DIV.OFFR.		[Signature]	[Signature]	
		NAME	SIGN	DATE

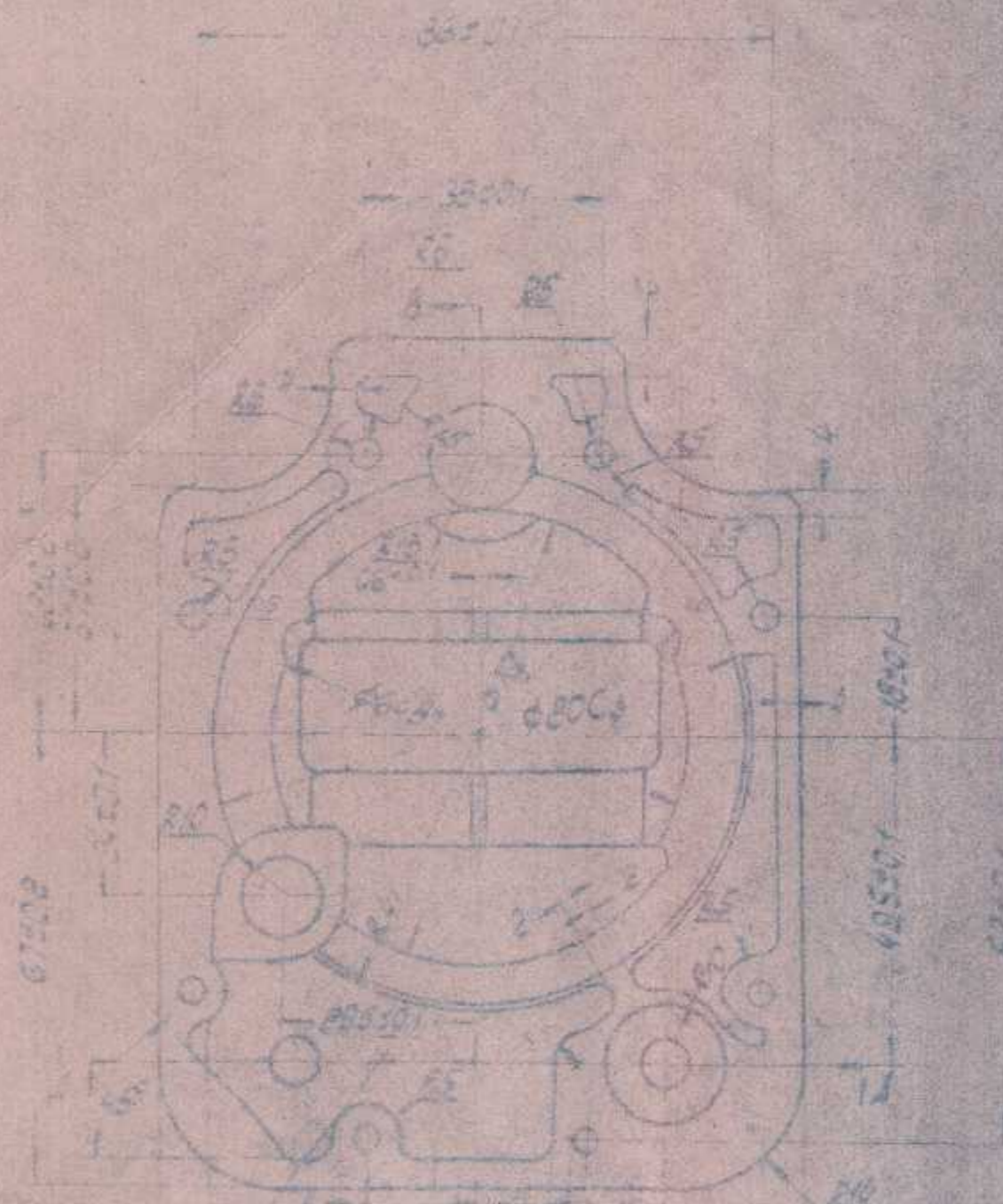
9D4.180.045

CONTAINER FOR
PACKING

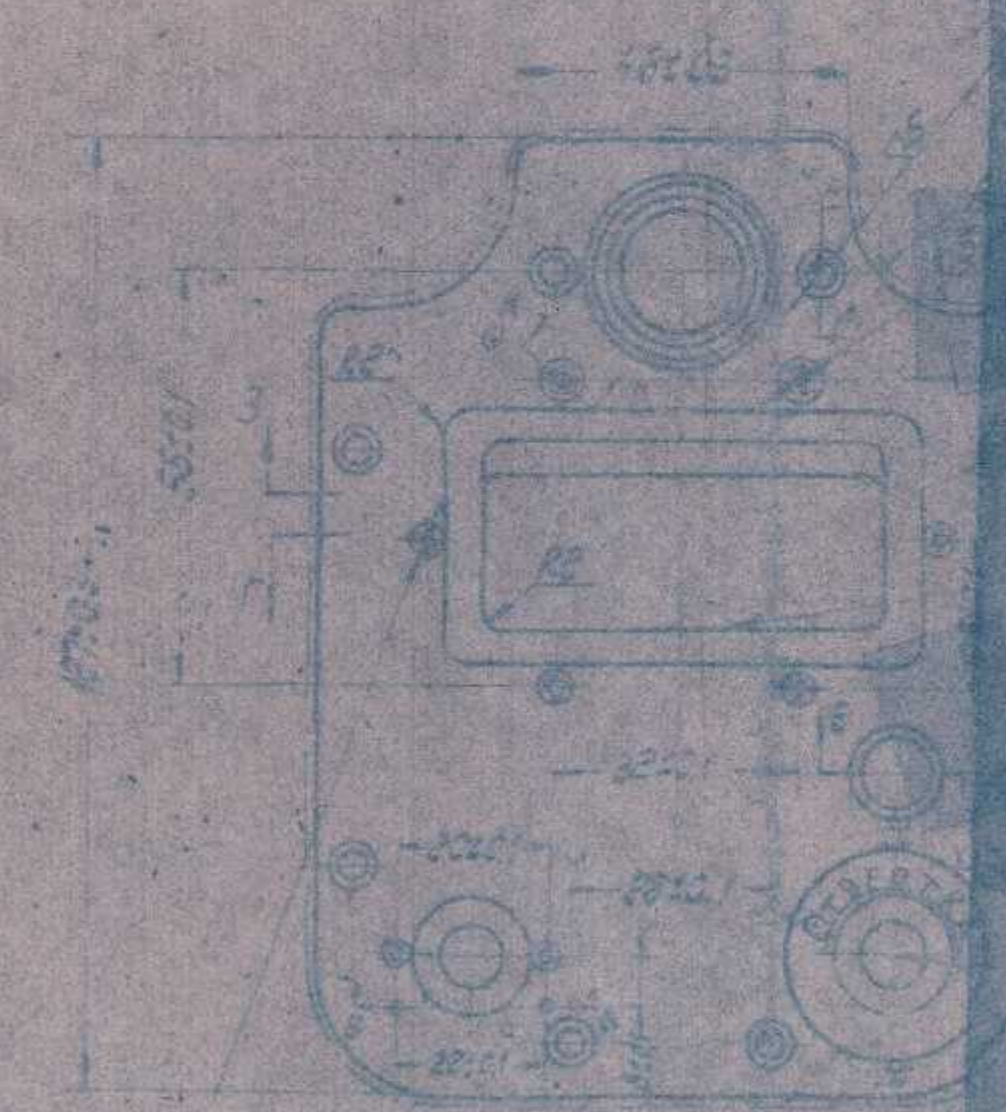
ГПК-59

SHT. NO	NO OFF SH
2	
ORDNANCE FACTORY PROJECT HYDERABAD	

View A (Revolved through 180°)



Place for heat treatment stamp.



Hole $\phi 3.2A_7$ counter sink $\phi 6$

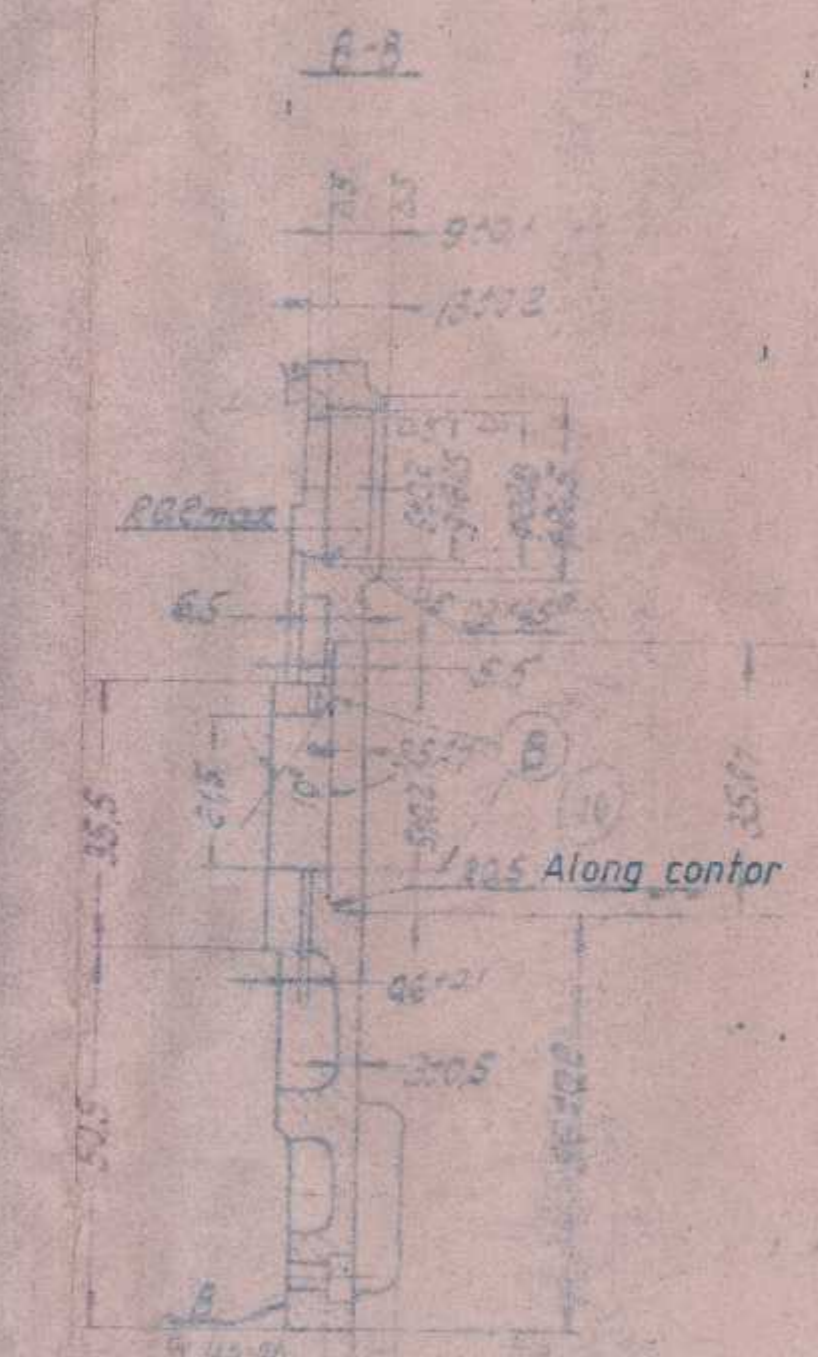
Drill 2holes M2 class 2 depth 3.5A₇ depth 4A₇ counter sink $\phi 2.5 \times 90^\circ$

4Holes $\phi 2.2A_7$ $\nabla 6$ counter sink $\phi 6$ $\nabla 5$

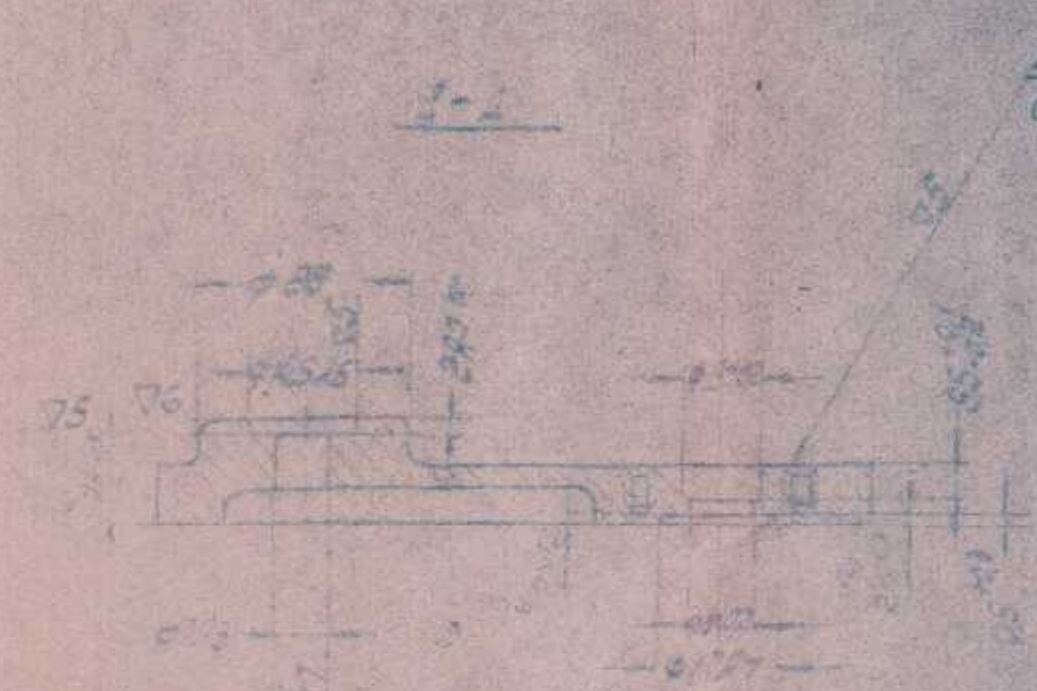
Machine along contour to $\nabla 5$



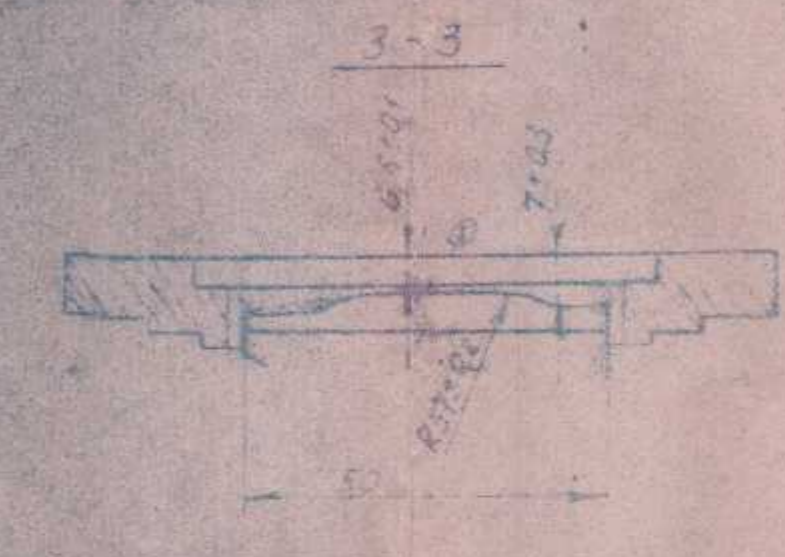
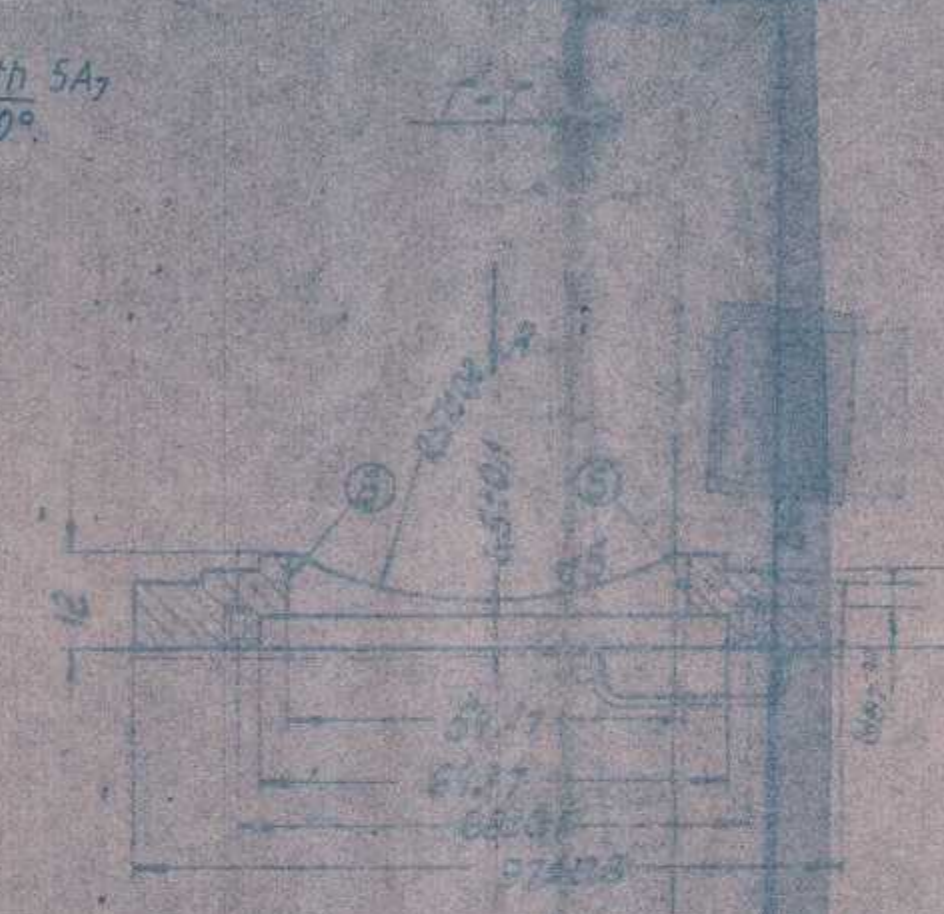
4Holes M2 class 2 $\nabla 6$ depth 6A₇ counter sink $0.3 \times 90^\circ$ $\nabla 5$



- 1). Part is made by pressure die casting class of accuracy $\nabla T-3$ as per OST 141154-72.
- 2). Ageing is performed after casting at $t=290 \pm 10^\circ C$ for 4hrs and at $t=-60^\circ C$ for 2hrs.

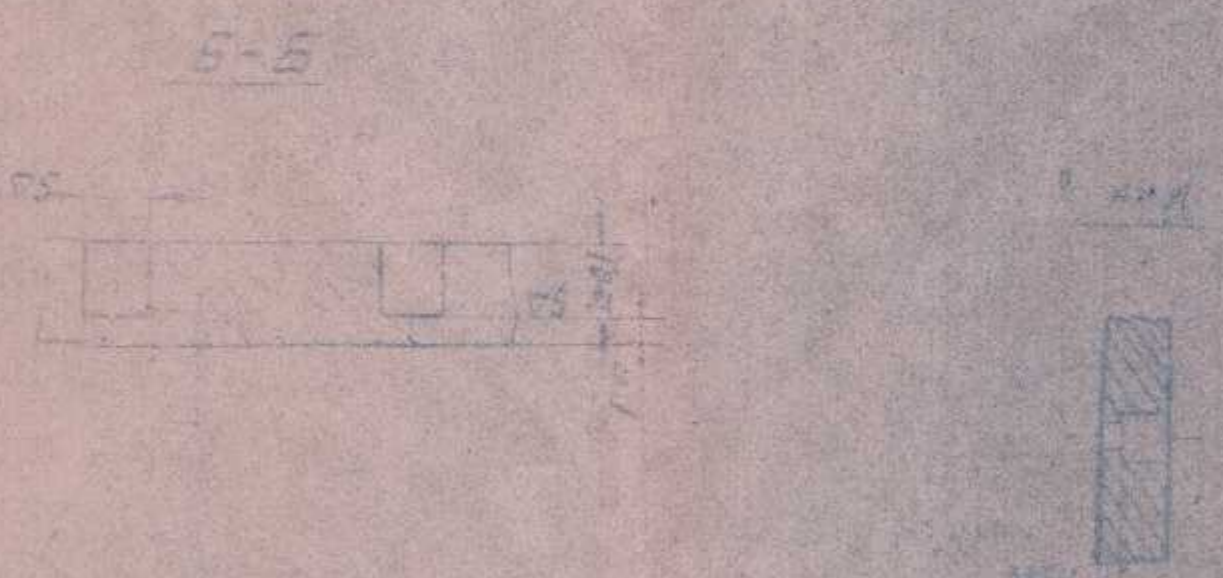


2Holes M3 class 2 depth 5A₇ counter sink $\phi 3.5A_7$ $\times 90^\circ$



Eccentricity

2Holes $\phi 2.2A_7$



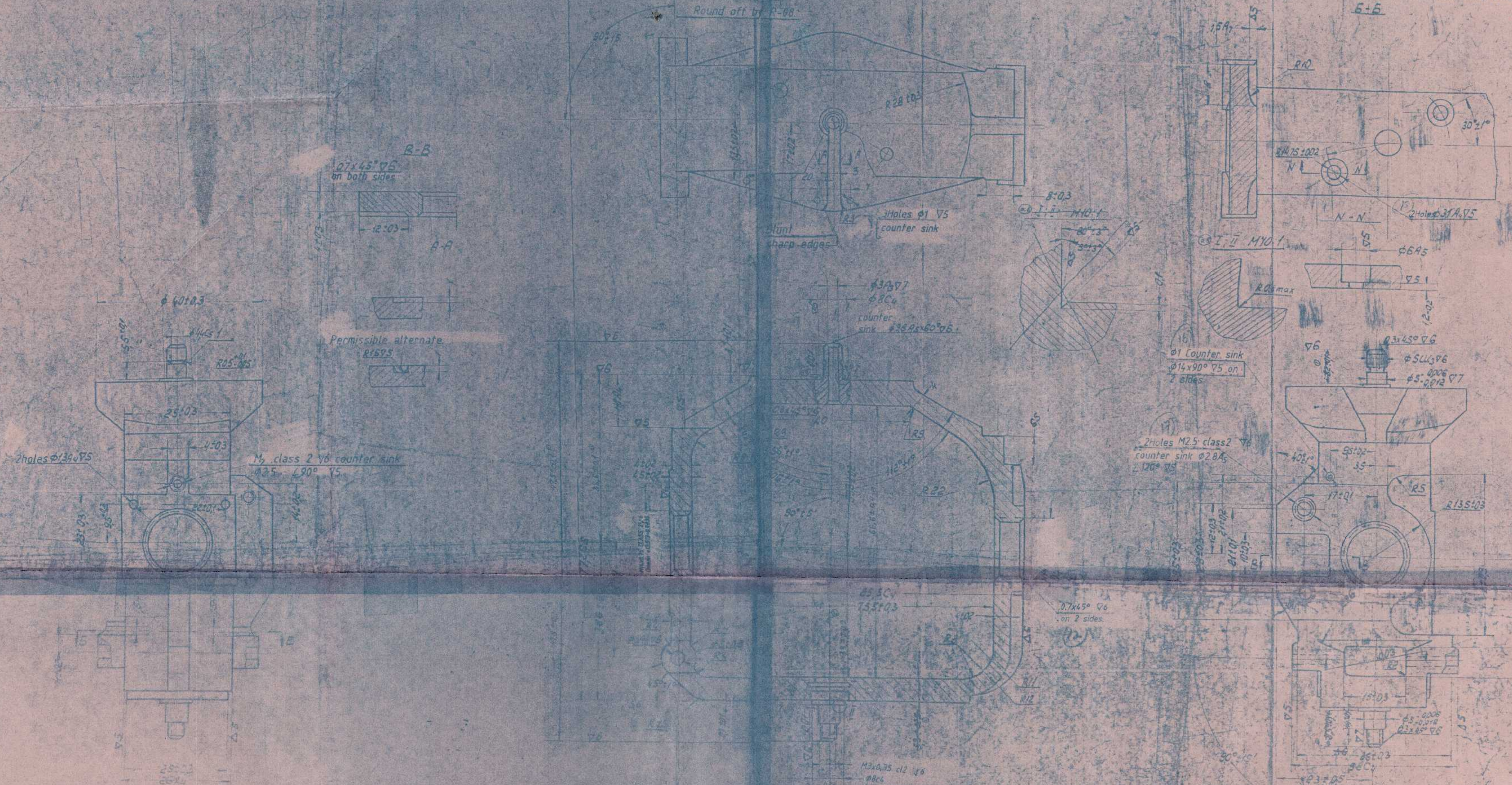
- 14). Pusher traces to a depth not exceeding 0.6mm is allowed on faces of $\phi 80$ and $\phi 64$.
- 15). Surface finish $\nabla 4$ is allowed as a result of flush dressing.
- 16). * Dimension 42 ± 0.2 is given for 2 holes of $\phi 3.5$ and upto the centre of boss $\phi 26.5$. Arrange hole $\phi 2.2A_7$ symmetrically with respect to centre of boss with deviation not exceeding $\pm 0.2mm$.
- 17). ** Maintain dimension 56 ± 0.2 for radius R3.2.
- 18). Non-flatness of surface B should be in the limits of 0.05mm.

19). Enamel M.1-165 may be specified in holes $\phi 3.2A_7$ and $\phi 13 \pm 0.2$ of other holes are protected against enamel.

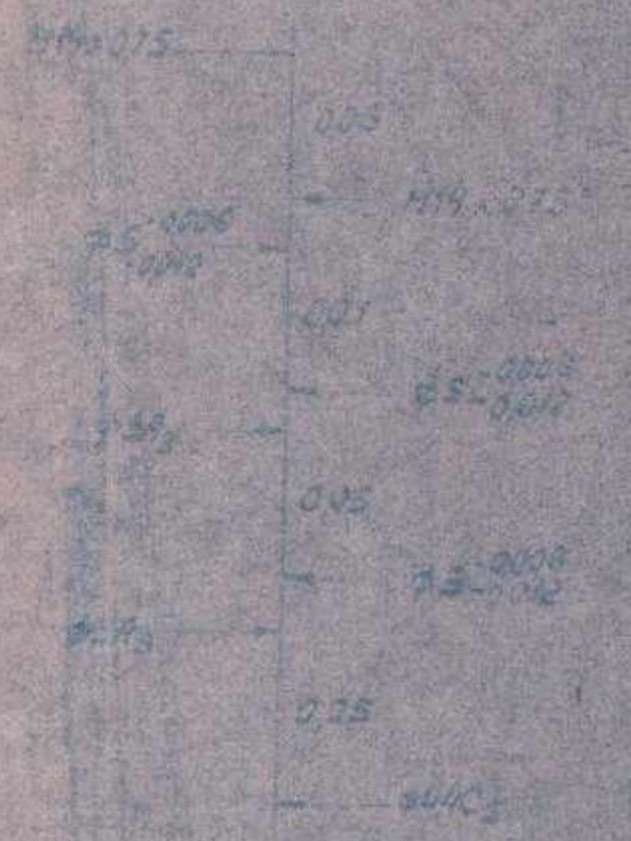
- 3). Radii not specified in drg are provided by upto R2
- 4). Tolerances on free dimensions are as per 722AT.
- 5). Coat surface B with enamel n ϕ 241 M III A black. THn ϕ -53 black may be used.
- 6). Make intriptions symmetrically with respect to the axis x-x with type 3-3 OST 100312-78. to a depth of 0.4 to 0.6.
- 7). Part may be made from alloy A.1-9. surface finish $\nabla 5$ may be provided instead of $\nabla 4$.
- 8). Surface indicated with are coated with M.1-165, silvery II 129.
- 9). Coat inscription screw ~~drive~~ with $\phi 3$ THn ϕ 53 black
- 10). Deviation of symmetrically arranged elements with axis of symmetry should be in the limits of tolerance on dimension.
- 11). Technical requirements are as per OST 80020-71 (2nd group).
- 12). Traces caused by the joints of rods are allowed on 21A₇.
- 13). Pattern draft for shaft - 30' towards increased dimensions, for holes - 1° towards decreased dimensions.

SINO SHEET NO	127-26
DRAWN BY	BHUSHAN
EDITED AND CHECKED BY	P. S. JAIN
FOREMAN OF DC	S. H. RAO
DIVISIONAL OFFICER	

FRONT WALL	
127-26	SHEETS WEIGHT SCALE
160 g	1.5
TOTAL SHEETS	
Aluminium alloy A.1-2	
GOST 2685-75	



1. Pressure die casting, class of accuracy AT3, as per OST 14.1154-72
3. Pattern draft of ext. contour -1°; internal -1°30' towards the dimension increase.
4. Perform unspecified radius by upto R 2.2 mm
5. Non inter sections of axes XX and YY should not exceed 0.02.
6. Ovality along $\phi 5^{+0.006}_{-0.012}$ should not exceed 0.003
7. Taper along $\phi 5^{+0.006}_{-0.012}$ should not exceed 0,003:5
8. M14x0.75 may be free from coating
9. Tolerances on free dimensions are as per 722 AT
10. Chemical oxidation.
11. Technical requirements are as per OST 1.80020-71 (2nd group)
12. Carryout ageing after casting at $\pm 220 \pm 10^\circ\text{C}$ for 3 hours followed by cooling in air.



Hole M2 class 2 V5 counter sink Ø2.2A5 ±0.008 Tap to a depth of 0.4

2 Holes M2 class 2 V5 counter sink Ø2.2A5 ±0.008 Tap to a depth of 0.4

Sl. No.	Designation	Description	Qty	Remarks
2		Aluminium Alloy A17-9		
1	948-340012-1	Axle	2	

SIN/SHEET	DOI/NO	SIGN	DATE
DRAWN BY	BHUSHAN		23/04
EDITED AND CHECKED BY	DR. JAIN		28/04
FOREMAN OF DC	SHARDA		28/04
DIVISIONAL OFFICER			

FRAME WITH AXLE

Aluminium Alloy A17-9
FOCT 2585-75